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**Fig. 9. Chuck Jaws with Floating Locating Points**

in position. The pocket *E* in the upper end of the centering plug is for clearance only. A heavy pin *K* acts as a driver against one of the wrist-pin bosses, so that the draw-rod and pin are not called upon to perform this part of the work.

While this chucking device is very rapid in its operation, there is no tendency to tilt the piston or distort it in any way.